

# ROTATIONAL GRIP TWIST MACHINE AND METHOD FOR FABRICATING BULGES OF TWISTED WIRE ELECTRICAL CONNECTORS

## Abstract of the Disclosure

5           Bulges in a wire having helically coiled strands are formed by untwisting the strands in an anti-helical direction at a predetermined position, to form an electrical connector from a length of the stranded wire. The wire is gripped by moving two spaced apart clamp members to a closed position and thereafter rotating the clamp members relative to one another in at least one complete relative revolution in a  
10   direction which is anti-helical relative to the coiled strands to form the bulge. The wire is gripped and rotated in the anti-helical direction for a relative rotational interval of greater than one-half, and preferably three-fourths, of a complete relative revolution. Thereafter, during the remaining rotational interval of each relative revolution, the clamp members are opened to permit the wire to be advanced to the  
15   next position where a bulge is to be formed.